

Date: Wednesday, 20/08/2008 12:48:55 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 41524
 Estimate Number : 11969
 P.O. Number :
 This Issue : 20/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : SMALL / MED FAB
 Previous Run : 40580
 Written By :
 Checked & Approved By :
 Comment : Est: E 02.04.15 Added Dwg Rev.B1NG
 Est Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified
 by:EC
 Part Number : D2065
 Drawing Number : D2065 REVC
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 28/08/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W049	304 RD Tube .500 x .049W
<p>Comment: Qty.: 1.7063 f(s)/Unit Total : 17.0625 f(s) 304 RD Tube .500 x .049W Seamless Tube batch: M108321 (7) M108823 (3) S108/08/20 (10)</p> <p>M110968 (10X) M.L. 09/04/22</p>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012. Note: 1 end only 2-Cut to length as per Dwg D2065 3-Form as per Dwg D2065 and template DT8251 4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template DT8251 5-Deburr</p> <p>S.B. 08/08/20 (10) (UX) M.L. 09/04/27</p>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>S.02/04/28 (210)</p>		
4.0	POWDER COATING	POWDER COATING
<p>Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3</p> <p>START TIME: 10:15 OVEN TEMPERATURE: 300° FINISH TIME: 10:45</p> <p>M105642 UMD/ Fd. 09/04/30 (X10)</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41524

Part Number: D2065

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-30

x 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST229

09/05/01

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



mf
09-05-01

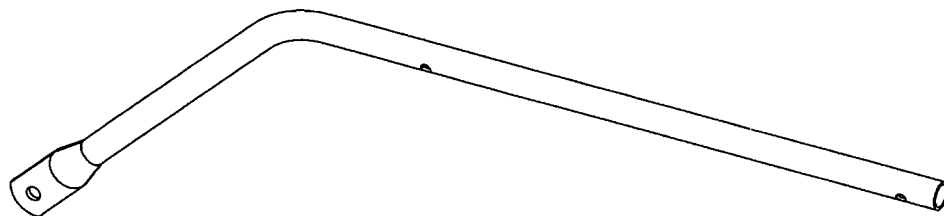
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D2065 ARM

RELEASED
08.07.23.118

Handwritten: 08/07/23

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE		PH	08.06.13
B	RE-DESIGN		BW	96.02.06
A	NEW ISSUE		BW	92.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2065 REV. C SHEET 1 OF 2 TITLE ARM SCALE NTS DATE 08.06.13		
DRAWN	PH			
CHECKED	PH			
MFG. APPR.	PH			
DE APPR.	PH			
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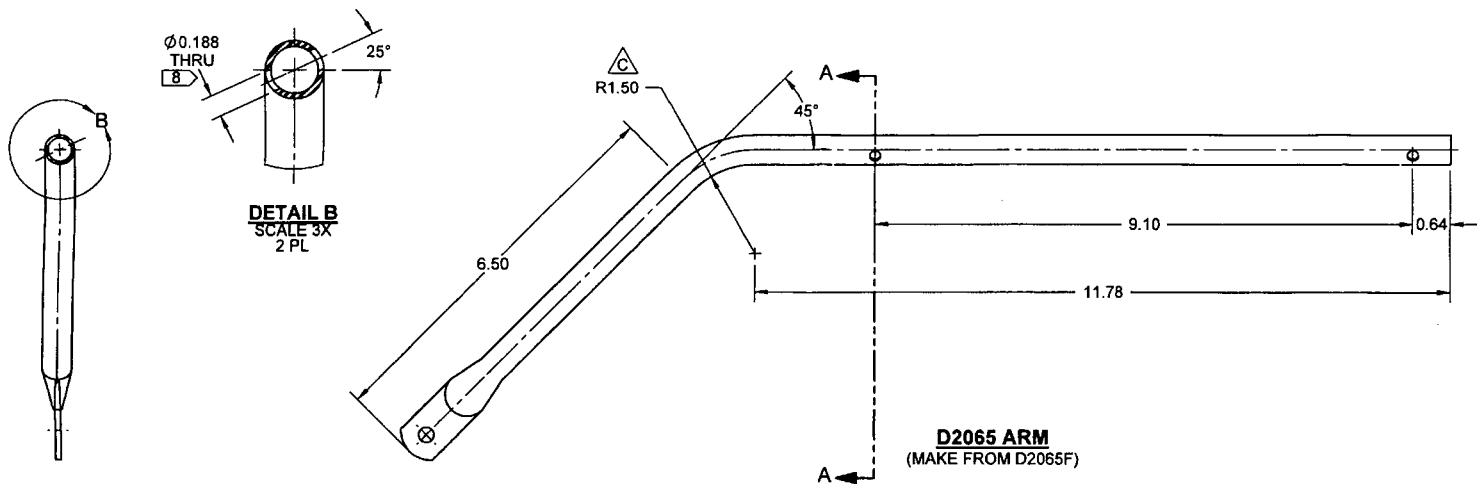
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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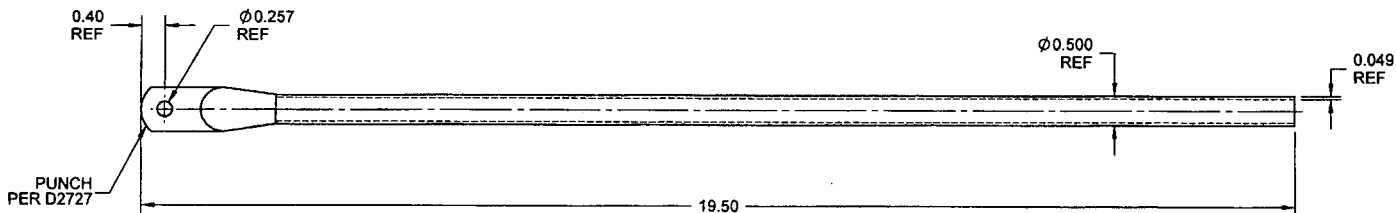
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8 7 6 5 4 3 2 1



SECTION A-A



D2065F ARM CUT LENGTH DETAIL

- NOTES:
- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.41 lbs
 - 8) DRILL $\phi 0.188$ AFTER BENDING

41524

RELEASED
08.07.23/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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